

Work Order ID 67027

Thursday, March 03, 2011 11:56:40 AM



Page 1

Item ID: D3822-7KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Lower-Grey

Start Date: 3/3/2011 Start Qty: 0.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3822	Rev C

100 0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

2

P167
B 11/04/02

105 0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 140

Time IN: 4:30

Time OUT: 7:00

11/04/01
11/04/02

2

B 11/04/02

W/O: 67027		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/14	#100	ADD correct information in header box.	Dh	11/04/14			S. 11/04/14

Part No: D3822-7KG4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67027

Thursday, March 03, 2011 11:56:41 AM



Page 2

Item ID: D3822-7KGY

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Lower-Grey

Start Date: 3/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA029 using tool DT9396
Dwg Rev:
Folio Rev:

2BB
11/04/02

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

2BB
11/04/02

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2Wh
11/04/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Revision ID:

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Item Name: Vertical Tunnel, Lower-Grey

Start Date: 3/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

2

BB
11/04/06

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

2

BB
11/04/06

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5/1/06

(2)

11-04-13
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item Name: Vertical Tunnel, Lower-Grey

Start Date: 3/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	Identify as per dwg & Stock Location: <u>150</u>	0.00							
Packaging 	Memo	0.00							
Packaging									
180 	QC21- Final Inspection - Work Order Release	0.00							
QC 	Memo	0.00							
Quality Control									

11/4/12

11/4/13

(See page 3) for
w/o closing
signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 03, 2011 11:56:47 AM

Page 1

Work Order ID: 67027



Parent Item: D3822-7KGY



Parent Item Name: Vertical Tunnel, Lower-Grey

Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	188.6071	2.16	2.161081			



Kydex steel grey



Location

Loc Qty

Loc Code

therm

111807

188.607054

188.607054

2

11/04/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67027
Description: Vertical Tunnel, Lower		Part Number:	D3822-7KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB Date: 11/04/06

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.20 - 0.15	Min	1.94	✓		Visual DL02	
0.060	Min	.068	✓		Visual DL02	

Measured by: JB Date: 11/04/06

Audited by: W.L. Date: 11/04/07

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ <u>JB</u>	<u>JB</u>

W/O:		WORK ORDER CHANGES					
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SHOP COPY

RETURN TO

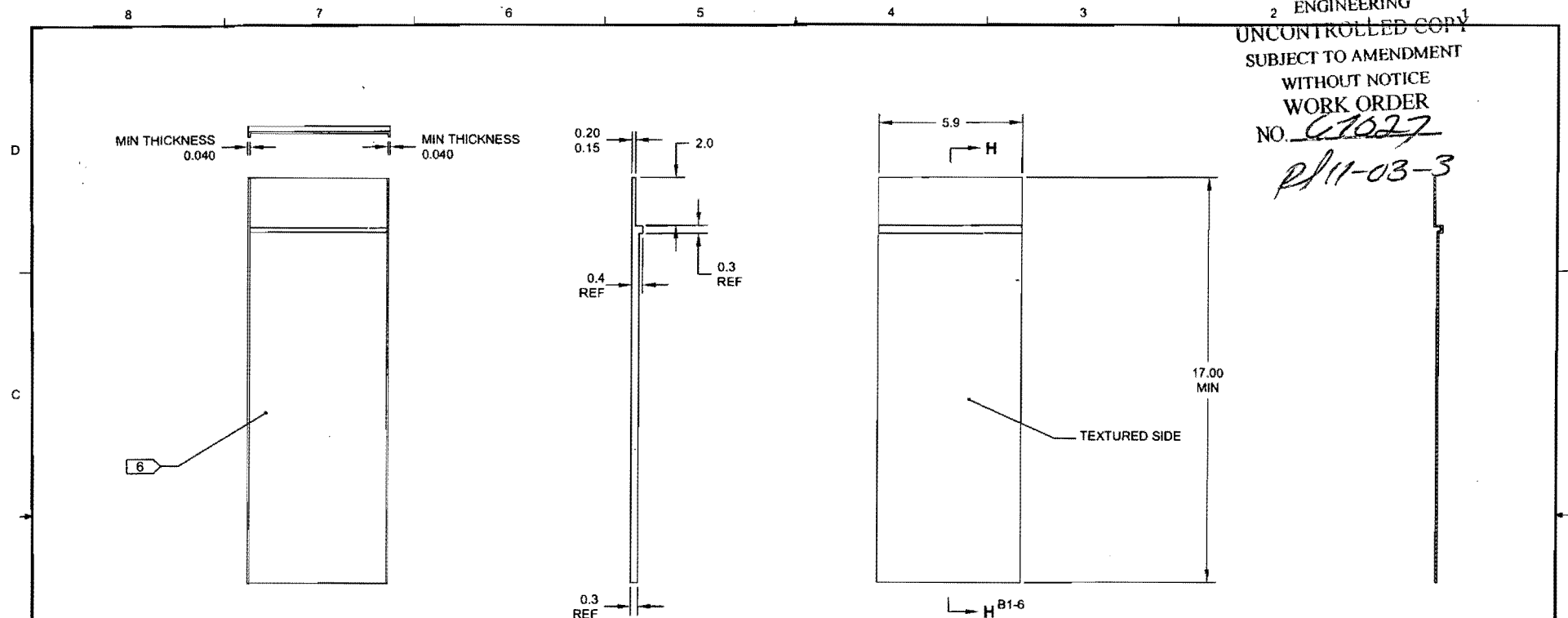
2 ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 67027P/11-03-3

SECTION H-H B3-6

D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	<i>BL</i>	DART AEROSPACE LTD	
DRAWN	<i>BL</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BL</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BL</i>	D3822	SHEET 6 OF 6
APPROVED	<i>BL</i>	TITLE	SCALE
DE APPR.	<i>BL</i>	VERTICAL TUNNEL (BELL 206 A/B)	NTS
DATE	09.05.05	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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RELEASED
09/05/22

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